Quality Control

Thursday, June	02, 2011 9:12:	20 AM									rage 1
Item ID: Revision ID: Item Name:	D3329-1 Bushing			Accept				s	etup Stai		
Start Date: Required Date: Reference:	6/2/2011	Start Qty: 12.00 Req'd Qty: 12.00		••	Cust Item I Customer:	D:	(1	VUS	3/		18/4 // 8 // 1 1 / 181
Approvals:		: Muc	Date: Date:	Tooling: SPC (Y/N):		ate:		R	tun Sta		
Sequence ID/ Work Center II		Operation Description	1 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4 4	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr		· · · · · · · · · · · · · · · · · · ·	4	1					
D3329	Rev A	A									
Hardinge CNC Lath	•	Hardinge CNC LATH Memo Machine	IE SMALL i as per Folio FA470 and Dwg	0.00 0.00 D3329□Deburr	1116/2			12	þ		
QC Quality Control		©C2- Inspect parts off	f machine FAI/FAIB	0.00	16/2			12	4		-
120 QC	2	QC8- Inspect parts - s	econd check	0.00	11.2-2	2		c2	4	` ; 	

Dart Aerospace Ltd

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W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	edory.	N	CR: Yes	No DO	Δ.	Date:	
		esolution:		,						
NCR:		,	WORK ORE	DER NON-CONFO	RMANC	E (NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Descrip	Section B	Sign &		cation	Approval Chief Eng	Approval QC Inspector
		- Occilon A	Chief Eng	Chief Eng		Date	3600		Officer Ling	QO IIISPECIOI
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NOTE: Date & initial all entries

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Work Order ID 70257

Thursday, June 02, 2011 9:12:20 AM



Page 2

Item ID:

D3329-1

Accept

Setup Start

Stop

Start

Revision ID:

Start Date:

Item Name:

Required Date: 6/3/2011

Bushing

6/2/2011

Start Qty: 12.00 Req'd Qty: 12.00

Date:

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Tooling:

SPC (Y/N):

Date: Date:

Tool # Plan

Code

Run

Accept

Qty

Stop

Sequence ID/ Work Center ID

130

Packaging Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

Memo

0.00

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Reject Reject Qty Number

Insp.

Stamp

M6/74)

Dart Aerospace Ltd

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W/O:			WO	RK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NC	CR: Yes	No DQ	A:	Date: _	
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NCR:			WORK ORDE	ER NON-CONFO	DRMANC	E (NCR)			
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	cation	Approval	Approval
	JILF	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

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Picklist Print

Thursday, June 02, 2011 9:12:18 AM

Work Order ID: 70257

Parent Item:

D3329-1

Parent Item Name: Bushing



Start Date: 6/2/2011

Required Date: 6/3/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP A□04.11.03□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			100	f	30.5570	0.0437	0.552			
										51	11/	6/2	_

303 Round Bar 1.00

<u>Location</u>	Loc Qty	Loc Code
MAT028	30.557	
116700	1.107	
117550	12	
117598	17.45	

Dart Aerospace Ltd

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W/O:			W	ORK ORDER C	ANGES		=			
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NC NC	R: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Dispositi	on:	Q/	A: N/C CI	osed:		Date: _	
NCR:		\	WORK ORE	DER NON-CONF	ORMANC	E (NCR)			
DATE	STEP	Description of NC		Corrective Action	Section B	1 0: 0	Verific	ation	Approval	Approval
- DAIL	JILF	Section A	Initial Chief Eng	Action Descr Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
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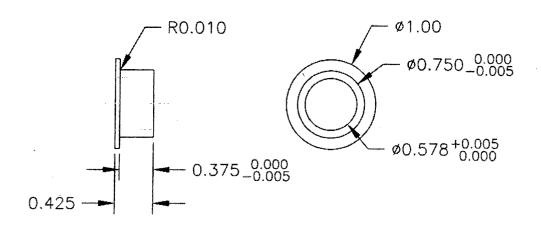
NOTE: Date & initial all entries





DESIGN	DRAWN BY	DART AEROSP HAWKESBURY, ONTARI	
CHECKED	APPROVED	DRAWING NO.	REV. A
4	1 - #	D3329	SHEET 1 OF 1
DATE		TITLE	SCALE
 04.10.29	· .	BUSHING	1:1
Α	04.10.29	NEW ISSUE	V.V.V.





D3329-1 BUSHING

70257

NOIES:

- 1) AISI 303 STAINLESS STEEL (REF DART SPEC. M303R1.000)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER.

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W/O:			V	WORK ORDER CH	IANGES					
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Part No	:	PAR #:	Fault Ca	ategory:	NCR:	Yes N	o DQA	۸:	_ Date:	
	R	esolution:	Disposit	tion:	QA: N	/C Clos	sed:		Date:	·
NCR:			WORK OR	DER NON-CONF	ORMANCE (NCR)				
DATE	STEP	Description of NC		Corrective Action	Section B		Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Descri		Sign & Date	Section	on C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 70257	
Description: Bushing	Part Number: D3329-1	
Inspection Dwg: D3329 Rev: A	Page 1 of 1	[

	FIRS	FIRST ARTICLE INSPECTION CHECKLIST										
	X	First Arti	cle	Prot	otype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o	n Con	nments					
1.00	+/-0.030	.287			84-	7						
Ø0.750	+0.000/-0.005	0.748										
Ø0.578	+0.005/-0.000	0.579										
				٠								
0.375	+0.000/-0.005	-345										
0.425	+/-0.010	.423										
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			<u></u>									
Measured by:	LL	Audited by:	20		Prototype	Approval:	N/A					
Date:	116/2	Date:	11.6	- 2		Date:	N/A					
Rev Date	Change					Revised by	Approved					

	Rev	Date	Change	Revised by	Approved
	Α	04.11.12	New Issue	KJ/JLM OK	
•					7. 7

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DATE	STEP	PROCEDURE		CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault	Category: NCR: Yes No DQA:				Date: _	· · · · · · · · · · · · · · · · · · ·		
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DATE	STEP	Description of NC	Corrective Action Section B		ion B	0: 0	Verification		Approval	Approval	
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NOTE: Date & initial all entries

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